

Friday, September 23, 2016 2:48:31 PM

151355

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 9/16/2016 **Start Qty:** 5.00 ***5***

Required Date: 9/23/2016 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: DAS Date: SEP 26 2016

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

Rev A

0.00

100

FLOW WATER JET

0.03

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2345 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

DAS
38
9-89
SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 151355

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151355

Page 2

Item ID: D2345 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Channel
Start Date: 9/16/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.02							
Brake NC	Form as per Dwg D2345 using DT8241								
	Remove tooling tab and buff flush								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.02							
Quality Control									

Handwritten notes:
- Blue ink: DAS 36 9-89
- Blue ink: 16/10/03
- Blue ink: 5X
- Blue ink: 5
- Blue ink: OCT 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID 151355

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151355

Page 3

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Revision ID: Stop ***NS2***
Item Name: Lock Channel
Start Date: 9/16/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.01							
Packaging	LOCATION : GA								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.08							
Quality Control									

5
OCT 04 2016
DAS
6
9-89

DAS
21
9-89
OCT 05 2016
VS 16/10/60

DAS
21
9-89
OCT 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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Root Cause			FAULT CATEGORY																		
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OTHER :																					

Picklist Print

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Page 1
1

Work Order ID: 151355

151355

Parent Item: D2345

D2345

Parent Item Name: Lock Channel

Start Date: 9/16/2016

Required Date: 9/23/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPPRevB99.05.31Re-formatDM
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	109.9240	0.0528	0.277895			

M304S18GA

PR 10/09/27

304/316 .050 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	101.024	
M133328	55.224	
M133587	0.7	
M134824	21.4	0.5
M134982	23.7	
MAT20	8.9	
M134580	8.9	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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☐ OTHER : _____					

DART

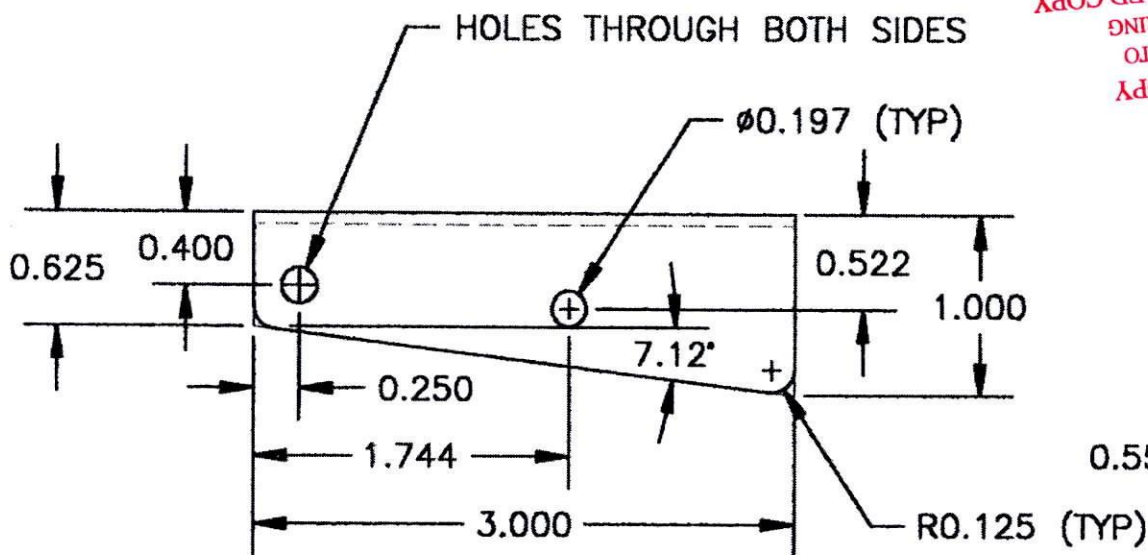
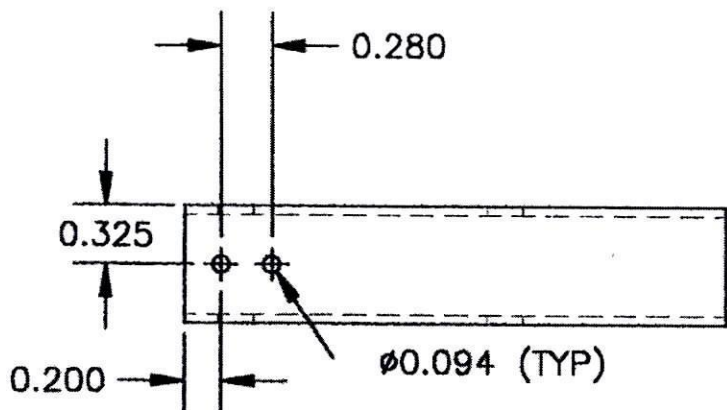


DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. D2345
DATE 95:02:21		SHEET 1 OF 2
		SCALE 1:1
		TITLE LOCK CHANNEL

RELEASED
99002 KE

NO. 151355 M.S.
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

16-09-26

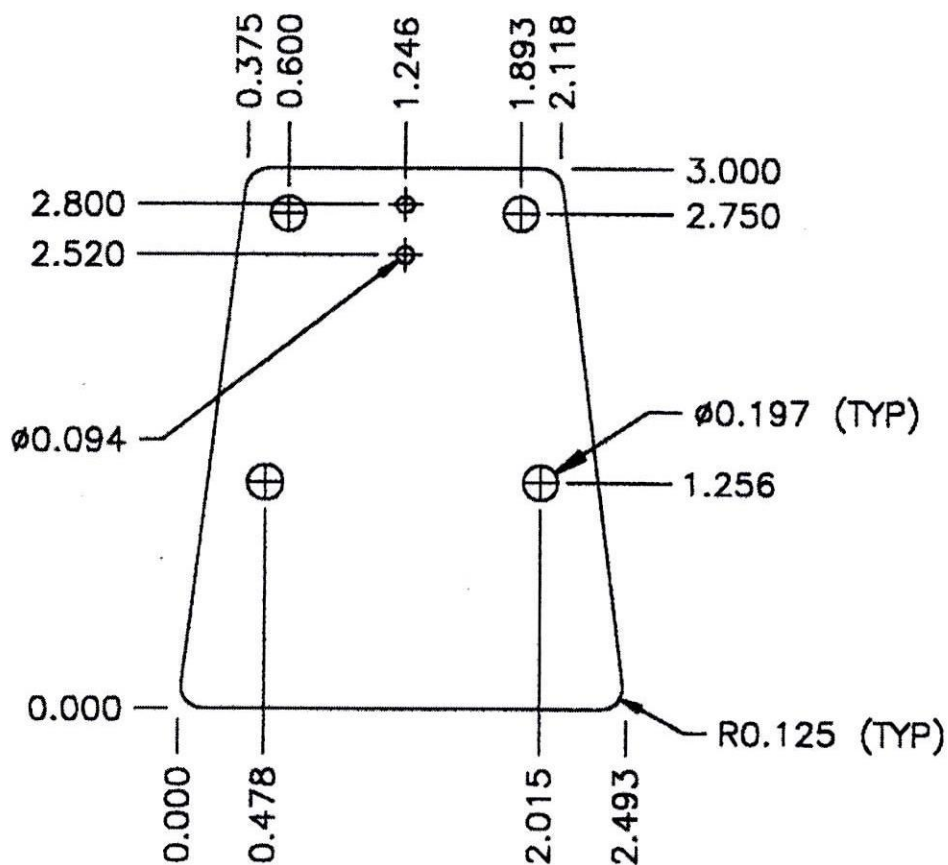


MATERIAL: 304/316 SS 0.050 THICK
BEND RADIUS: 0.032



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	[Signature]	D2345	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:21		LOCK CHANNEL	1:1

RELEASED
001.06.02 KE



D2345 FLAT PATTERN
MATERIAL: 304/316 SS 0.050 THICK